

Work Order ID 54316

December 7, 2009 3:10:06 PM



Page 1

Item ID: D3770-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 07/12/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

PL

Date:

09-12-7

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3770

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3770 2-drill holes thru to finish size as per dwg D3770 Using DT9410, Locate tube on stop labelled #1 and then drill holes labelled #1 23- deburr

(60)

lpl 10/01/05

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8/10/10/7

counter
(60)

p

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-01-7

(60)

φ.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54316

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Page 2

Item ID: D3770-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 07/12/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAD



10-01-07

60

140 Identify as per dwg & Stock Location: 250A

0.00



Packaging

Memo

0.00

Packaging

PC 10/01/07 (60)

150 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/07 AJ
MF 10-01-07

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Picklist Print

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Page 1

Work Order ID: 54316

Parent Item: D3770-1

Parent Item Name: Tube


Comments:

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	58.3994	71.7347			
												
6061T6 RD TUBE 1.00 x .065w												

CP 10/01/05

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

58.3994082

110778

2.18

111029

56.2194082

m113511



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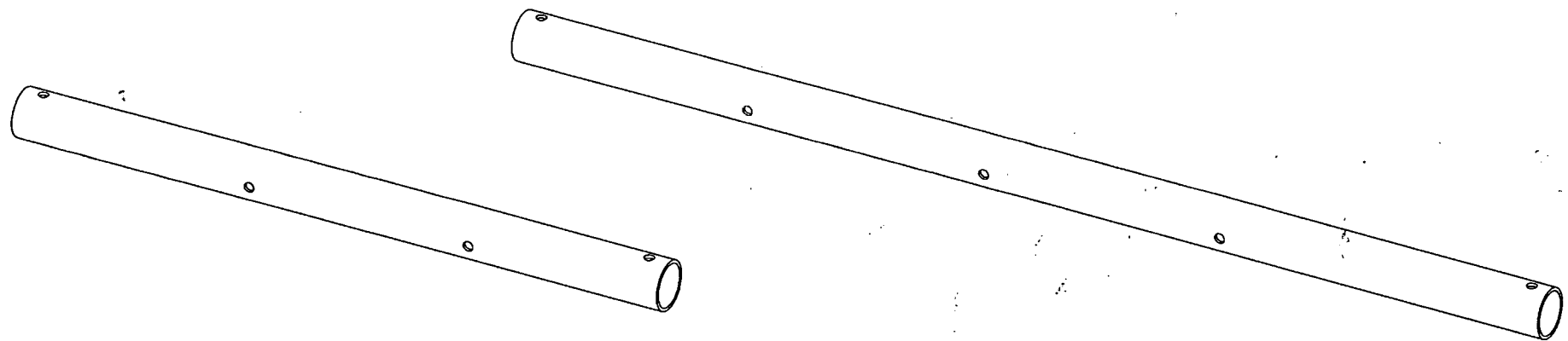
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SHOP COPY
 RETURNED
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO APPROVAL
 WITHOUT
 WORKMANSHIP
 NO. 54316

B409-12-7



D3770-1 TUBE

D3770-3 TUBE

RELEASED
 08-07-10

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3770-1, 0.25 lbs
 D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	AS	D3770	SHEET 1 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	TUBE	NTS
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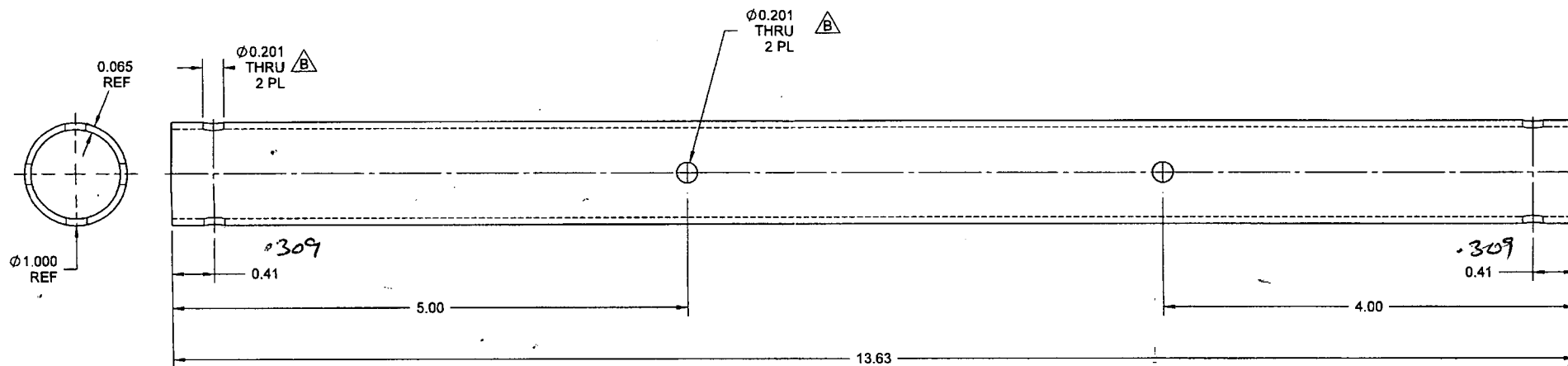
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D3770-1 TUBE

RELEASED
08.07.10

W/0 54314

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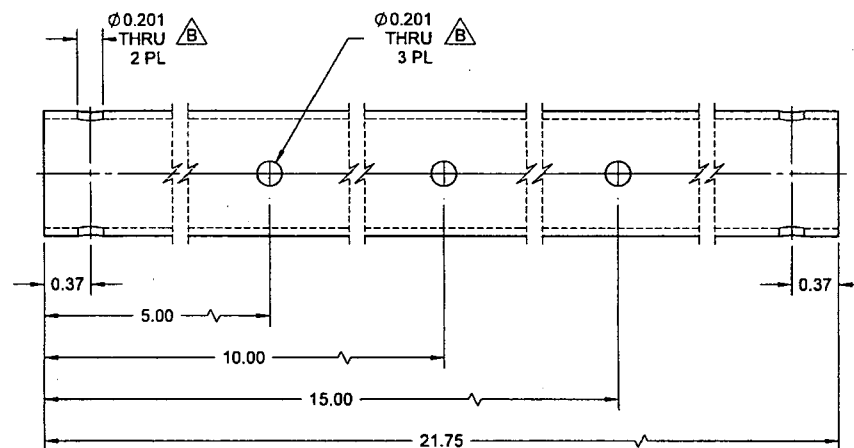
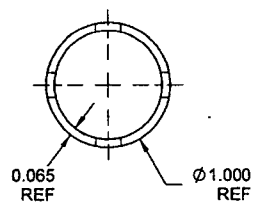
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D3770-3 TUBE

RELEASED
05.07.10/11

W/0 34316

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